

Work Order ID 63673

Tuesday, November 09, 2010 2:22:18 PM

Page 1

Item ID: D3953-3

Accept

Revision ID:

Item Name: Gas Spring Stud, Lid

Start Date: 11/9/2010 Start Qty: 8.00

Required Date: 11/16/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: MFDate: 10-11-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Doosan

Doosan Lathe

Memo

Turn as per folio FA852 & DWG

FOLIO REV: AADWG REV: C

DEBURR

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 11/16/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	J.A 10/11/12			8			
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>101</u> Memo	0.00 0.00							<u>10/11/12</u> (S)
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10-11-12</u> (S)

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Picklist Print

Tuesday, November 09, 2010 2:22:17 PM

Page 1

Work Order ID: 63673



Parent Item: D3953-3



Parent Item Name: Gas Spring Stud, Lid

Start Date: 11/9/2010


Required Date: 11/16/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750  304 SS Roundbar .750		Purchased	No			100	f	29.0947	0.125	1.052632		10.11.11	

Location

MAT028

Loc Qty

29.09473684

Loc Code

113216

17.8447368

103457

11.25

1.0

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DART AEROSPACE LTD		Work Order: 62673
Description: Gas Spring Stud, Lid		Part Number: D3953-3
Inspection Dwg: D3953	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.75	+/-0.030	.75	/		Vernier	all ID - 02
0.56	+/-0.010	.560	/			
0.281	+/-0.010	.281	/			
1/4-28 UNF-2A	N/A					
Major Ø	Max = 0.2490 Min = 0.2425	.248	/			
M.O.W.	Max = 0.26687 Min = 0.26357	.265	/			
Ø0.098	+0.004/-0.001	.098	/			
Ø0.250	+/-0.010	.247	/			
0.170	+/-0.010	.173	/			
0.330	+/-0.010	.330	/			
0.13	+/-0.030	.13	/			
R0.06	+/-0.030	R.060	/			
1.31	+/-0.030	1.30	/			

Measured by: [Signature]	Audited by: J.A	Prototype Approval:	N/A
Date: 10-11-12	Date: 10/11/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ [Signature]	[Signature]

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

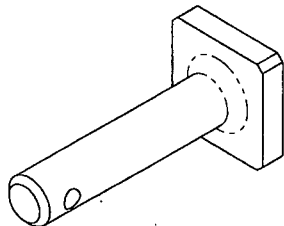
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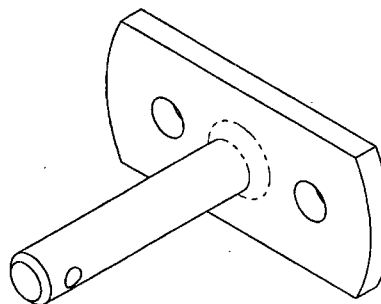
8 7 6 5 4 3 2 1



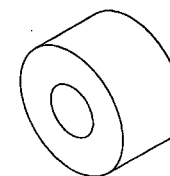
D3953-1 GAS SPRING BRACKET
(FULL LID)



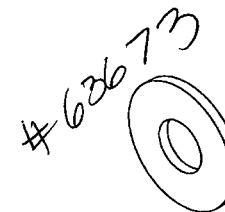
D3953-3 GAS SPRING STUD, LID



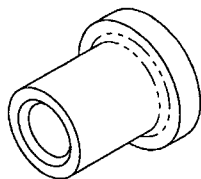
D3953-5 GAS SPRING STUD, BASE



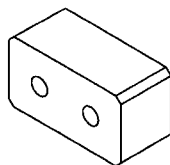
D3953-7 GAS SPRING SPACER



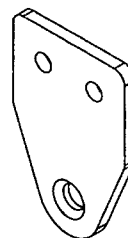
D3953-9 GAS SPRING WASHER



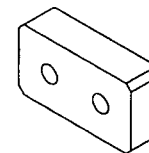
D3953-11 GAS SPRING SPACER



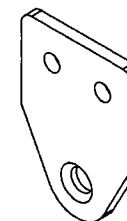
D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)

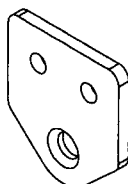


D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
R 2010-02-26



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



8 7 6 5 4 3 2 1

C	PARTS -19 & -21 ADDED (SHT 1 & 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED, REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3953	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

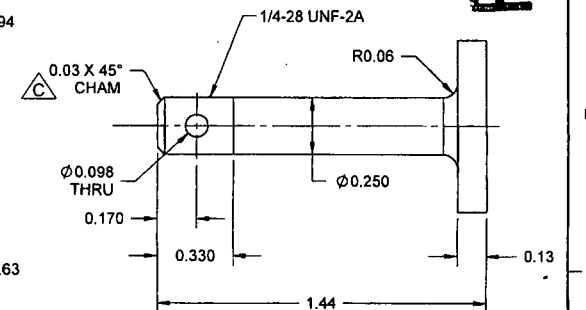
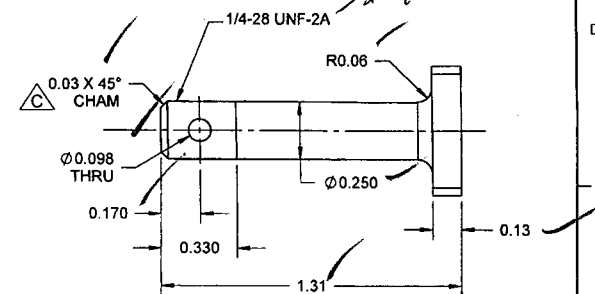
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1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AIS1 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
 -3: 0.03 lbs
 -5: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATELY PROPRIETARY PROPERTY OF THE DART CORPORATION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION. 800-645-6744 EXT. 1000	REV. C
DRAWN	JPH		SHEET 2 OF 4
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		

RELEASED
2010-02-26

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